

Date: Tuesday, 25/11/2008 2:04:56 PM  
User: Melanie Fauteux

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 43726		
Estimate Number	: 10671		
P.O. Number	:	Part Number	: D29701
This Issue	: 25/11/2008 S.O. No. :	Drawing Number	: D2970 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 33220	Material	:
Written By	:	Due Date	: 02/12/2008 Qty: 20 Um: Each
Checked & Approved By	: <u>MF 08-11-25</u>		
Comment	: Est: B 01.06.07 Added Material and Tool number SM/EC Est Rev:C Now on Waterjet 07-06-27 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025 SHEET
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Comment: Qty.: 0.3833 sf(s)/Unit Total : 7.6650 sf(s)  
1010/1025/A21/6aA SHEET  
20 GauGE .040"  
Batch: 109289 B 8-11-26  
108275

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D2970  
Dwg Rev: A B 8-11-26  
Prog Rev: A  
  
2-Deburr if necessary B 8-11-26

(26)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 8-11-26

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

508/4/26 counter  
(426)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
Deburr and form on brake using DT8178 and DT8261 as per Dwg D2970

58/11/26 (26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: WEARPLATE

Job Number: 43726

Part Number: D29701

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Soslu/26 (426) counter

7.0

POWDER COATING

POWDER COATING



M 109 648



(26x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:10  
320 °F  
2:40

MF 08/11/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FX 08/11/26 (26)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-16

FX 08/11/26 (26)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/27

Job Completion



MF 08-11-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

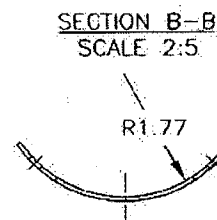
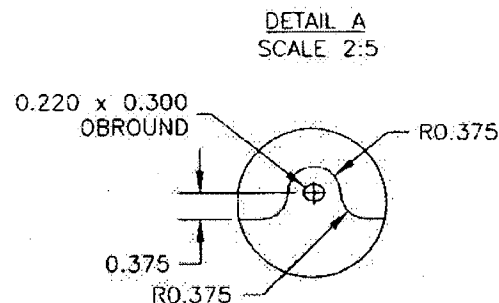
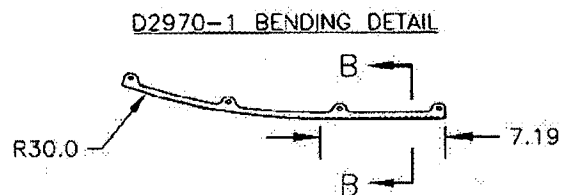
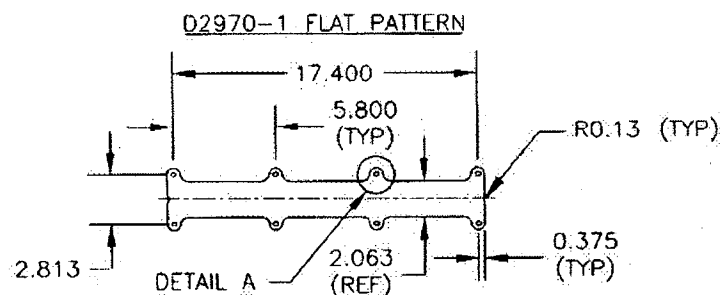
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

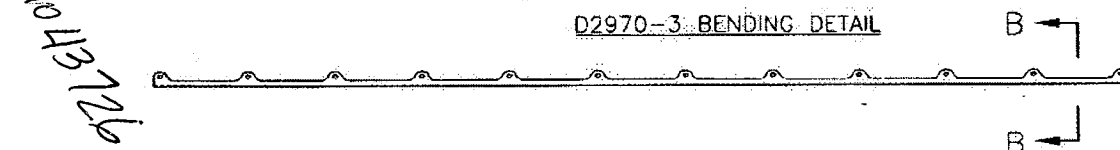
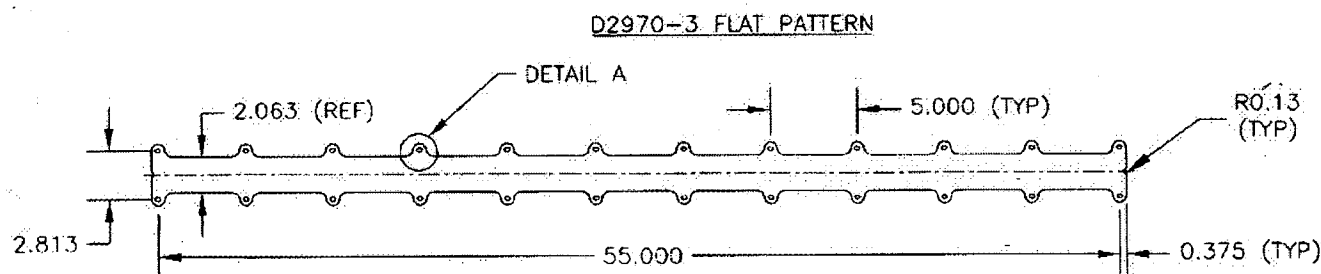
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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REFERENCE ONLY



BREAK ALL SHARP EDGES 0.010 TO 0.020  
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL  
 20 GAUGE (0.040 THICK)  
 FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005-4.3  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 ALL DIMENSIONS ARE IN INCHES

RELEASED  
 00.05.11

**DART**



DESIGN	RF	DRAWN BY	RF	<b>DART AEROSPACE USA, INC.</b> BELLEVUE, WA
CHECKED	RF	APPROVED	RF	
DATE	00.03.10	DRAWING NO.	D2970	REV. A
		TITLE	WEARPLATE	SHEET 1 OF 1
A	00.03.10	NEW ISSUE		SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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